

Date: Thursday, 08/11/2007 10:30:46 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ACCESS PANEL ASSEMBLY			
Job Number	: 34240		Part Number	: D3259041			
Estimate Number	: 12948		Drawing Number	: D3249 REV A1			
P.O. Number	: N/A		Project Number	: N/A			
This Issue	: 08/11/2007	S.O. No.	: N/A		Drawing Revision	: A1	
Prsht Rev.	: NC		Material	: N/A			
First Issue	: 23/08/2007	Type	: SMALL /MED FAB		Due Date	: 03/09/2007	
Previous Run	: 33655		Qty:	4		Um:	Each
Written By	: <i>[Signature]</i>		Comment	: Est Rev:A New Issue 07-07-19 JLM Verified By:EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
2.0	D32591	panel	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) panel Batch: <u>34736</u>		<i>Cd</i>
3.0	D32593	Doubler	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Doubler Batch: <u>B34201</u>		<i>Cd</i>
4.0	D32595	Spacer	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Spacer Batch: <u>B34737</u>		<i>Cd</i>
5.0	D32597	Door	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Door Batch: <u>342543X</u> <u>B34738</u>		<i>Cd</i>

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Seq. #:	Machine Or Operation:	Description :
6.0	D31615	Hinge 9.9"
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Hinge 9.9" Batch: <u>B33671 1K</u> <u>B34 735 3X</u> <u>6</u>
7.0	D32601	Spring
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Spring Batch: <u>34255</u> <u>6</u>
8.0	127H5	HALF GROMMET
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) HALF GROMMET Batch: <u>M10 5518</u> <u>6</u>
9.0	250018C3Y	RIGHT RECEPTACLE
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) RIGHT RECEPTACLE Batch: <u>M10 0034</u> <u>6</u>
10.0	2501W20020C3Y	STUD
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) STUD Batch: <u>100 398</u> <u>6</u>
11.0	MS20426AD44	Rivet
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s) Rivet Batch: <u>1021</u> <u>6</u>
12.0	MS20470AD34	Rivet,Universal Head
		Comment: Qty.: 36.0000 Each(s)/Unit Total : 144.0000 Each(s) Rivet,Universal Head Batch: <u>15541</u> <u>6</u>

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Seq. #: Machine Or Operation:

Description :

13.0 MS20470AD35

Rivet



Comment: Qty.: 10.0000 Each(s)/Unit Total : 40.0000 Each(s)

Rivet

Batch: 9682

Le 7/11/09

14.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3259-041 as per Dwg D3259.

Note: Keep .040" Gap all around door.

ml 07/11/09 x4

15.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

do 07/11/09 (x4)

16.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: ST 182

AS 07/11/09

(4)

17.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 07/11/10

Job Completion



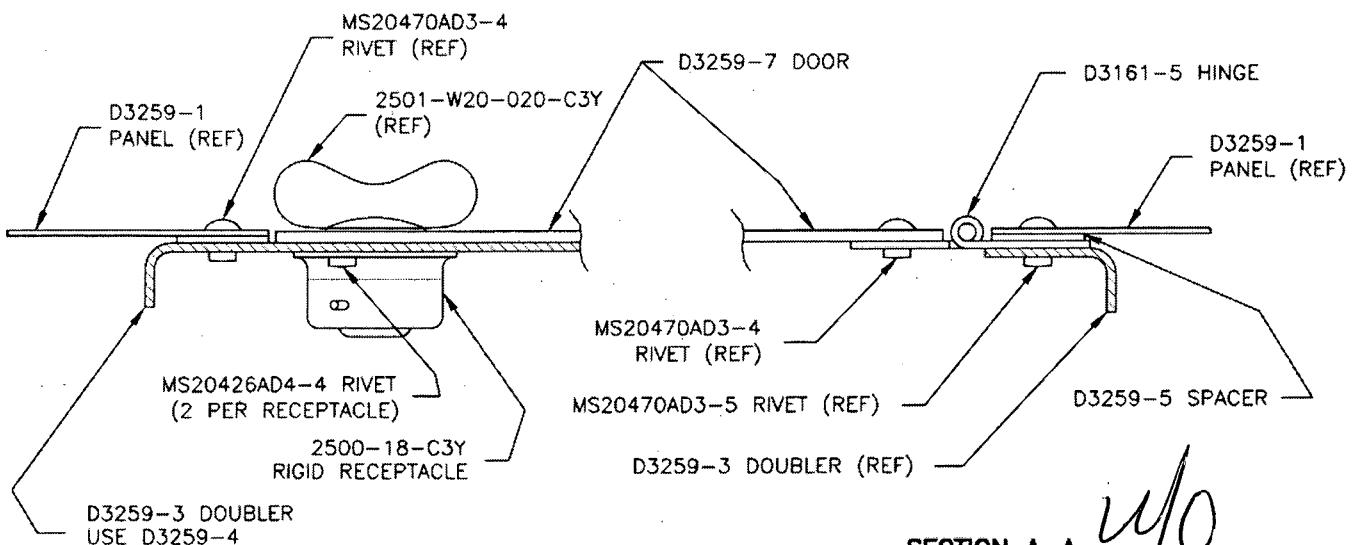
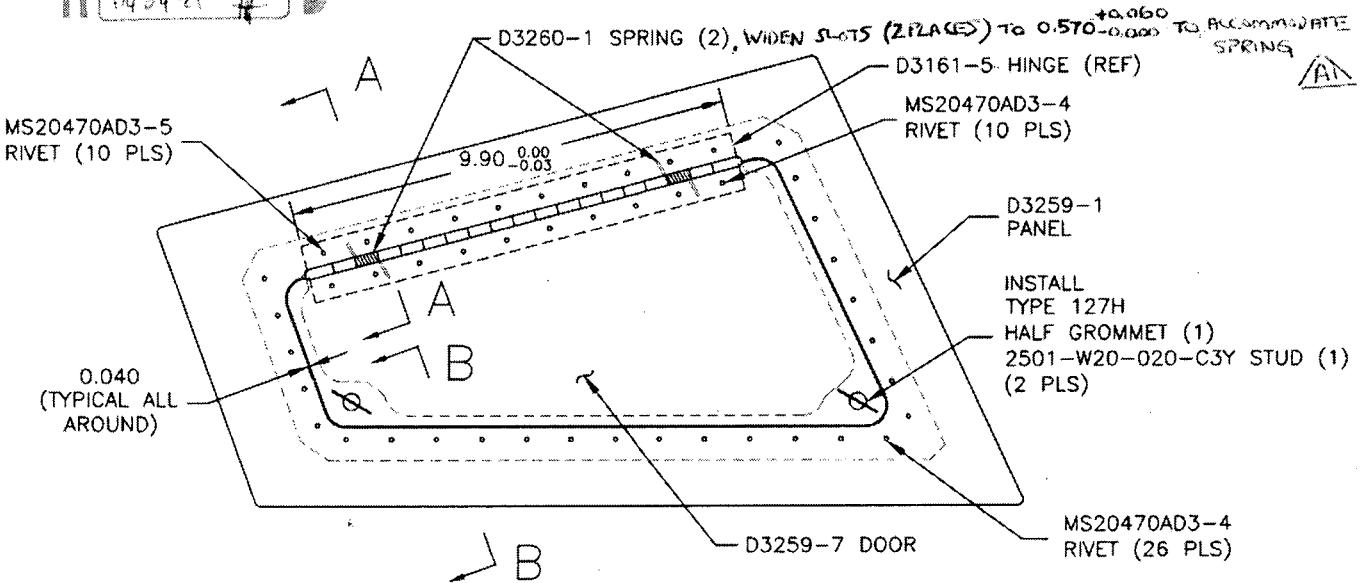
AS 07/11/12

DART

DESIGN RF	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3259
DATE 04.02.25		REV. A SHEET 1 OF 6 TITLE ACCESS PANEL ASSEMBLY SCALE 1:4

RELEASED
04.02.21

A	04.02.25	NEW ISSUE
A1	UP-A 04.08.11	WIDEN SLOTS TO ALLOW OPERATION OF SPRINGS



SECTION B-B
VIEW ROTATED

SECTION A-A
VIEW ROTATED

D3259-041 ACCESS PANEL ASSEMBLY (SHOWN)
D3259-042 ACCESS PANEL ASSEMBLY (OPPOSITE)

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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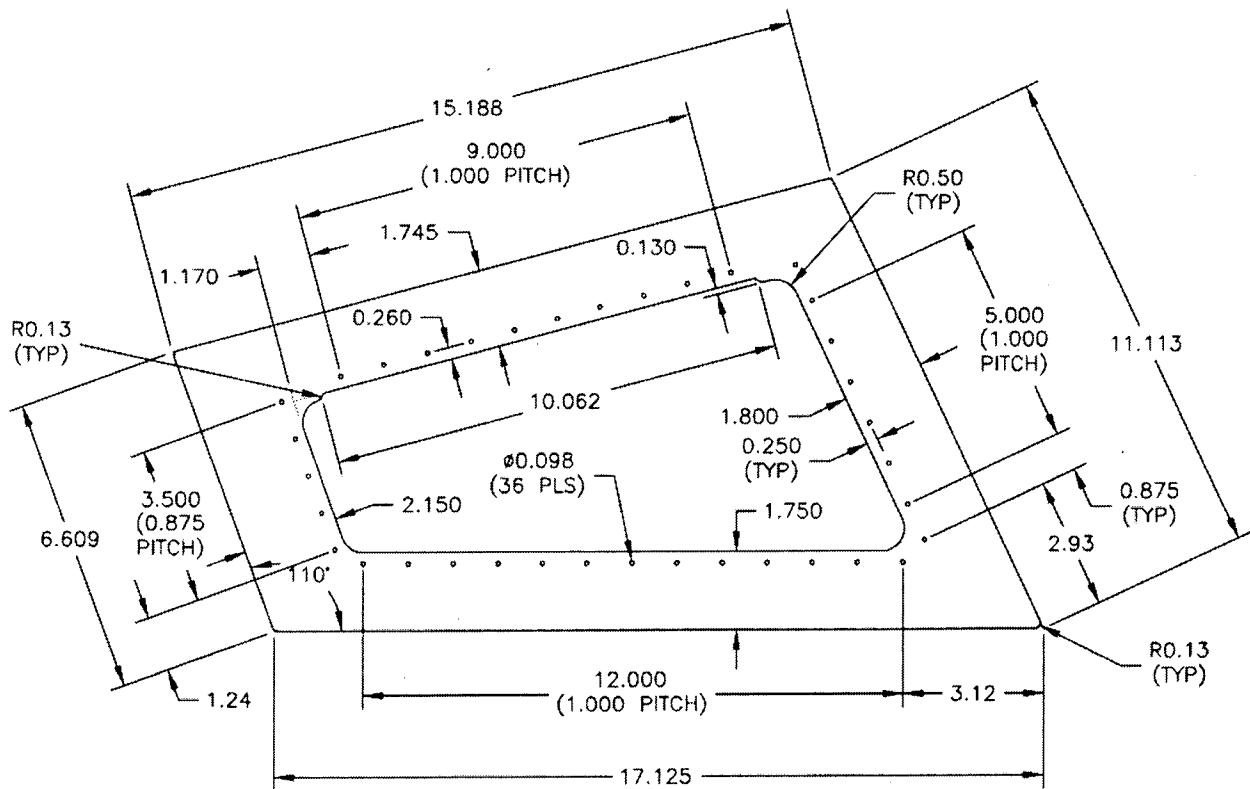
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W/O
34240



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CHECKED	APPROVED	DRAWING NO. D3259 REV. A SHEET 2 OF 6
DATE	TITLE	SCALE 1:4 ACCESS PANEL ASSEMBLY

RELEASED
[Signature]



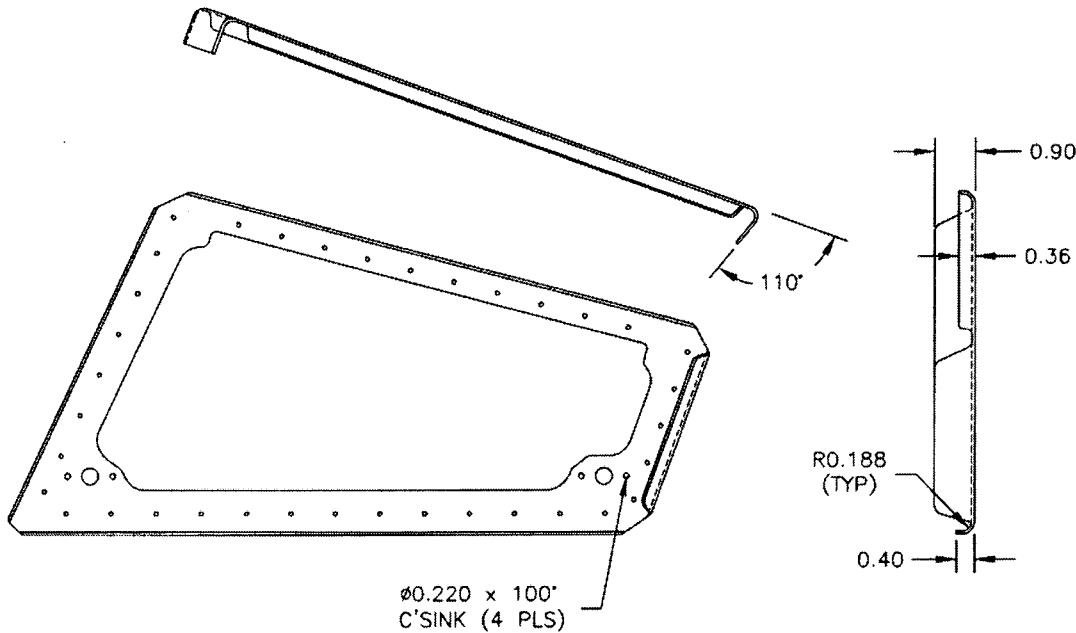
D3259-1 PANEL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

DART

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CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3259	REV. A SHEET 3 OF 6
DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14 CFS**D3259-3 DOUBLER BEND DETAIL (SHOWN)**

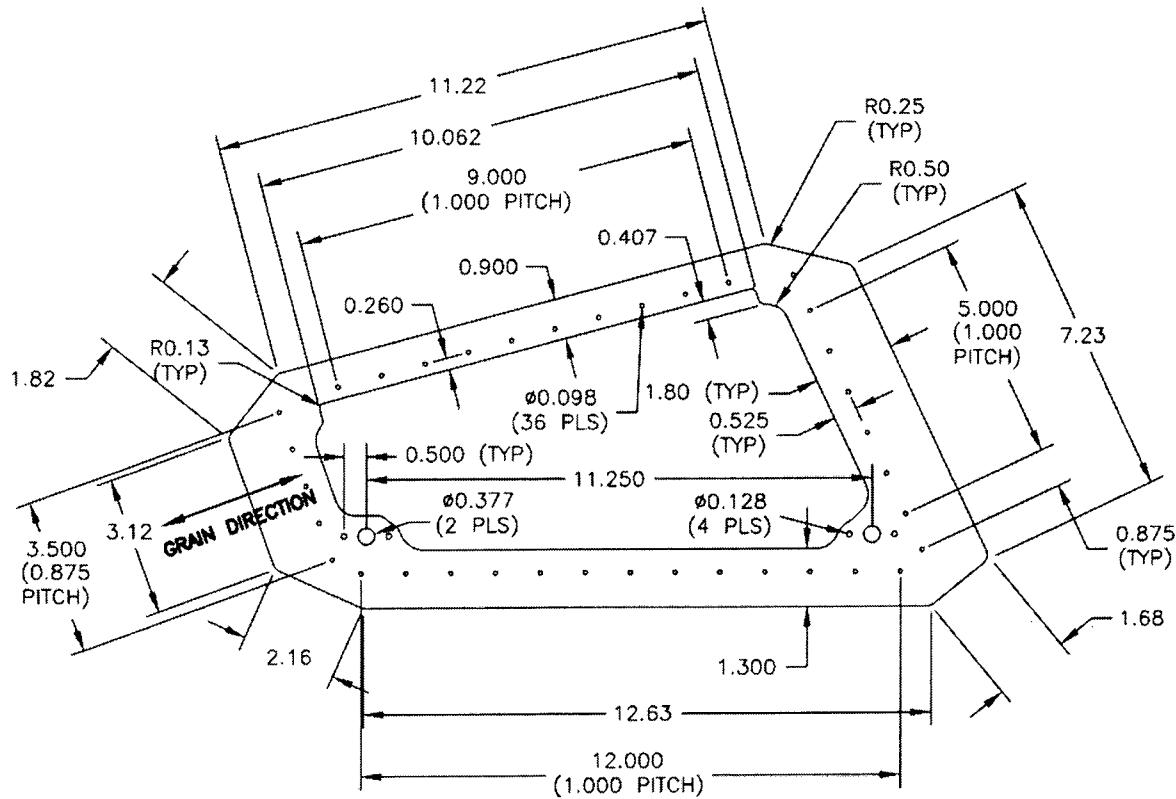
BEND D3259-4 DOUBLER (OPPOSITE)

D3259-3/-4 NOTES:

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

DART

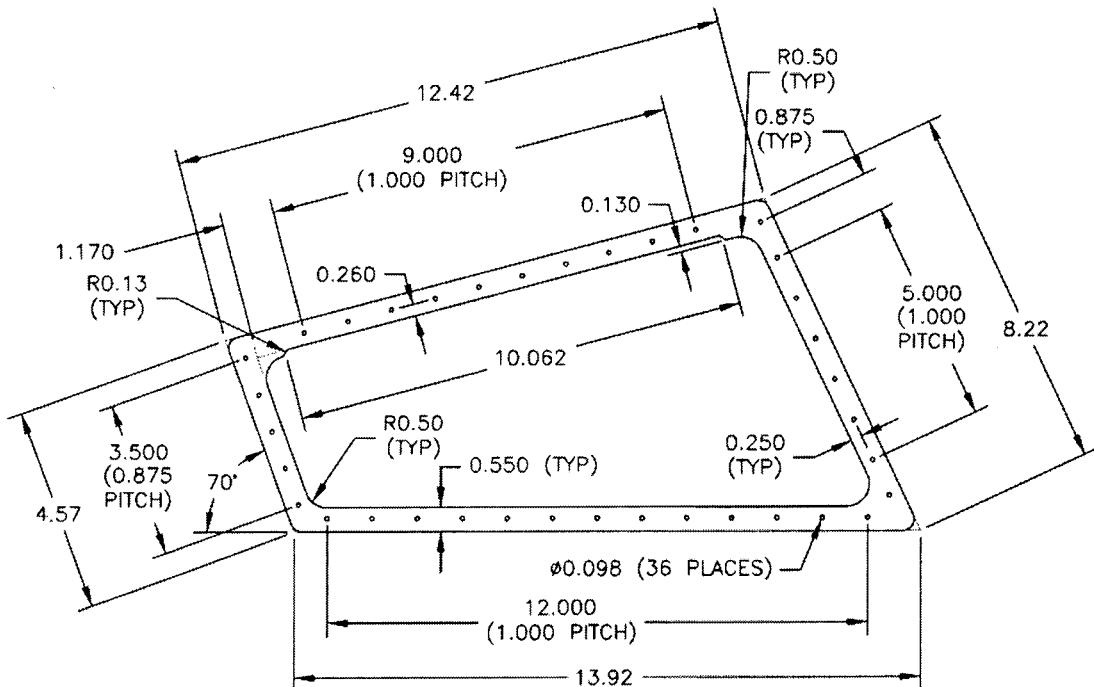
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3259 REV. A SHEET 4 OF 6
DATE	04.02.25	TITLE SCALE ACCESS PANEL ASSEMBLY 1:4

RELEASED
04-09-14**D3259-3/-4 DOUBLER FLAT PATTERN**

(Ø0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

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DATE 04.02.25	TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4	

RELEASED
04.02.25**D3259-5 SPACER**

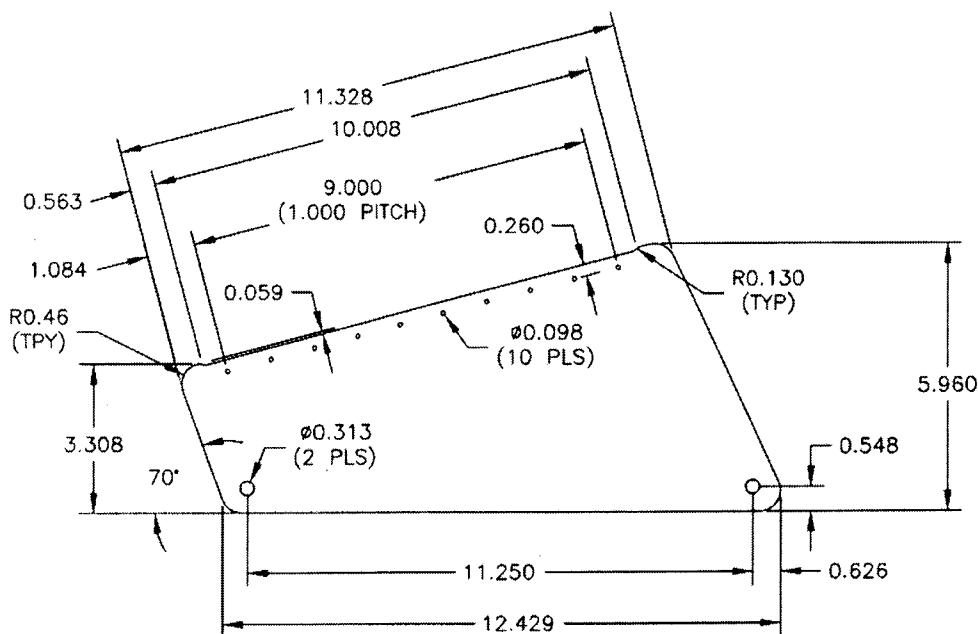
(Ø0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

NOTES:

- 1) MANUFACTURE PER "D3259-A5.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14 *[Signature]***D3259-7 DOOR**NOTES:

- 1) MANUFACTURE PER "D3259-A6.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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